



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D2873-045
Job Sheet 214659



Part No: D2873-045

Job Qty: 40 pcs

Part Name: Nut Plate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/28/20

Job Tracking No:

Due Date: 11/19/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP A 05.09.13 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	40 pcs			0.00	0.35	Bandsaw - 1		ALA 20/11/17
110	HAAS 4 Axis - B4B	40 pcs			1.00	10.15	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
							NV5000 - 1 - B4B		ALA 20/11/17
							NV5000 - 2 - B4B		
120	QC 2	40 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



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CANADA
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Container No: S313644



Part: D2873-045

Job No: 214659

Serial No/Batch: S313644

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/17/20

DAS
86
9-89

ALA 20/11/17

			QC 2 - 57	
			QC 2 - 62	
			QC 2 - 63	
			QC 2 - 8	
			QC 2 - 66	
			QC 2 - 64	
			QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 2 - 86	
			QC 2 - 83	
130 QC 8	40 pcs	0.00 0.00	QC 8 - 12	
			QC 8 - 14	mk 20/11/18
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
			QC 8 - 66	
			QC 8 - 73	
			QC 8 - 82	
140 Small Fab - 2 - B4B	40 pcs	0.00 1.12	Small Fab - 1 - B4B	
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	DAS
			Small Fab - 4 - B4B	21
			Small Fab - 5 - B4B	9.80
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	DAS
150 QC 5	40 pcs	0.00 0.00	QC 5 - 10	21
			QC 5 - 12	5.02
			QC 5 - 17	
			QC 5 - 18	

				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				QC 5 - 82	
160	Handfinish - 1-1 Chemical-B4B	40 pcs	0.00 0.82	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	DAS
				Handfinish - 1 - 22 - B4B	47 NOV 20 2020
170	QC 7	40 pcs	0.00 0.00	QC 7 - 10	9-89
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	DAS
				QC 7 - 51	58 NOV 25 2020
				QC 7 - 58	9-89
				QC 7 - 59	
				QC 7 - 60	

			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	
			QC 7 - 82	
			QC 7 - 87	
180 Small Fab - 3 - B4B	40 pcs	0.00 1.12	Small Fab - 1 - B4B	DAS 58 NOV 25 2020 9-89
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
190 QC 5	40 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	DAS NOV 25 2020 40 9-89
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
200 Packaging 3-1 - Stock - B4B	40 pcs ✓	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B ✓	NOV 25 2020 DAS LG050 80 9-89
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	

			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	DAS
210 QC 21 - SA	40 pcs	0.00 0.00	QC 21 - SA - 21	21 NOV 2 5 2020
			QC 21 - SA - 70	9-89
			QC 21 - SA - 9	
			QC 21 - SA - 77	
			QC 21 - SA - 28	

Part Op 100 - (Bandsaw) Cut blanks: 1.000" x 0.375" x 2.700" long
 Descriptions: 110 - HAAS1-2 (HAAS CNC Vertical Machine) Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev
 A F1819Folio Rev AB
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Small Fab) 1-Deburr
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (Chemical Conversion Coat per QSI005 4.1)
 170 - (QC7-Inspect Chemical Conversion Coat)
 180 - (Small Fab) 1-Assemble as per Dwg D2873 2-Identify as D2873-045
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____) (Identify as per dwg & Stock Location: _____) LOCATION :
 LG050
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X1.000	6061T6 Bar .375 X 1.00	9 ft (.225 ea)	100-Bandsaw - 1	5290948
MS20426AD4-6	Rivet	160 Ea (4 ea)	180-Small Fab - 3 - B4B	5301564
MS21075L5	Nut Plate	80 Ea (2 ea)	180-Small Fab - 3 - B4B	5305134
				5310991

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.375X1.000	9	37	0
180-Small Fab - 3 - B4B	MS20426AD4-6	160	2,336	0
	MS21075L5	80	340	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order: 214659
Description: Radius Block		Part Number: D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.501			VLRN.	ALA-01
1.000	+/-0.010	.998			"	"
0.750	+/-0.010	.749			"	"
0.250	+/-0.010	.250			"	"
1.000	+/-0.010	1.000			"	"
2.000	+/-0.010	2.000			"	"
Ø0.128	+0.005/-0.001	.129			"	"
0.359	+/-0.010	.360			"	"
Ø0.316	+0.006/-0.001	.315			"	"
1.000	+/-0.010	1.000			"	"
0.250	+/-0.010	.251			"	"
0.061	+/-0.010	.062			"	"
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.230 x .126			"	"

Measured by: ALA	Audited by: [Signature]	Prototype Approval:	N/A
Date: 20/11/17	Date: 20/11/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM [Signature]	[Signature]

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QSI042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			